

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: 206/OH-58	SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 35227				
Estimate Number	: 12930				
P.O. Number	: N/A		Part Number	: D29322UP	
This Issue	: 10/18/2007	S.O. No. : N/A	Drawing Number	: D2932 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A	Type : MACHINED PARTS	Drawing Revision	: C	
Previous Run	: 34730		Material	: N/A	
Written By	: <u>HJ 07.10.18</u>		Due Date	: 11/5/2007	Qty: 8 Um: Each
Checked & Approved By	: <u>HJ 07.10.18</u>				
Comment	: Est Rev: A	New Issue 07-07-04 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: B 34/644

20 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

40 QC1. INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:04:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 35227

Part Number: D29322UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 07/11/23 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/11/26 (8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/11/28 (8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 445

07/11/28 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28 (8)

Job Completion



07/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35227
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.117	.118	.119	.120		
B	0.100	0.140		.116	.119	.121	.118		
C	0.100	0.140		.117	.120	.119	.117		
D	0.210	0.230		.221	.220	.220	.221		
E	1.245	1.255		1.250	1.249	1.250	1.249		
F	1.245	1.255		1.250	1.251	1.250	1.248		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.578	1.578	1.572	1.577		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.115	.122	.122	.122		
O	0.540	0.560		.552	.549	.548	.546		
P	0.490	0.510		.498	.500	.500	.495		
Q	3.715	3.725		3.719	3.718	3.719	3.719		
R	2.470	2.510		2.494	2.492	2.492	2.493		
S	0.240	0.270		.249	.251	.253	.253		
T	0.100	0.180		.145	.145	.143	.143		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.369	1.367	1.365	1.365		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.135	1.135	1.136		
Y	1.565	1.585		1.575	1.574	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA
Date: 07.11.18

Audited by: 85
Date: 07/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35227
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

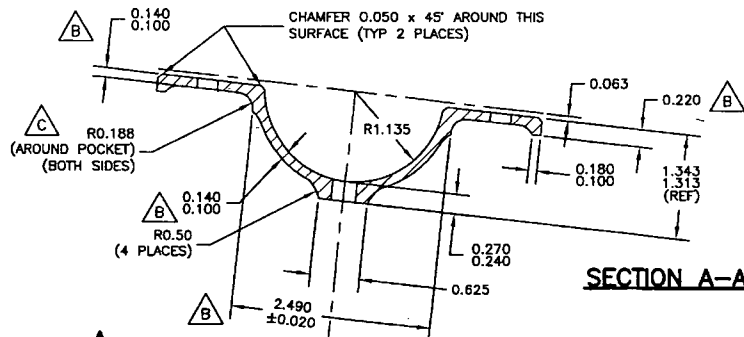
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	.120	.122	.121		
B	0.100	0.140		.120	.120	.118	.119		
C	0.100	0.140		.118	.119	.118	.119		
D	0.210	0.230		.220	.2205	.221	.220		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.495	2.497	2.497	2.497		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.315	.313		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.122	.121	.123	.122		
O	0.540	0.560		.550	.550	.557	.551		
P	0.490	0.510		.509	.508	.499	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.492	2.493	2.495		
S	0.240	0.270		.254	.254	.254	.255		
T	0.100	0.180		.143	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.321	.321	.321		
X	1.125	1.145		1.1335	1.134	1.133	1.1335		
Y	1.565	1.585		1.572	1.573	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

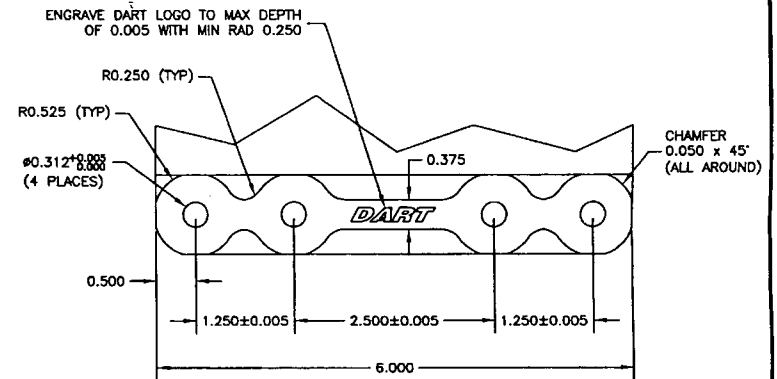
Measured by: <i>SD</i>
Date: 07.11.19

Audited by: <i>8-5</i>
Date: 07/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A

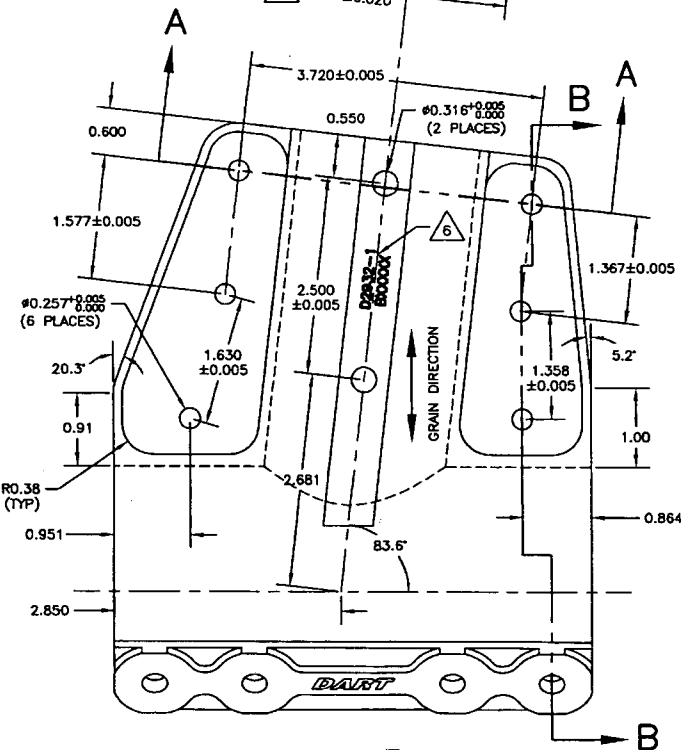


VIEW C-C

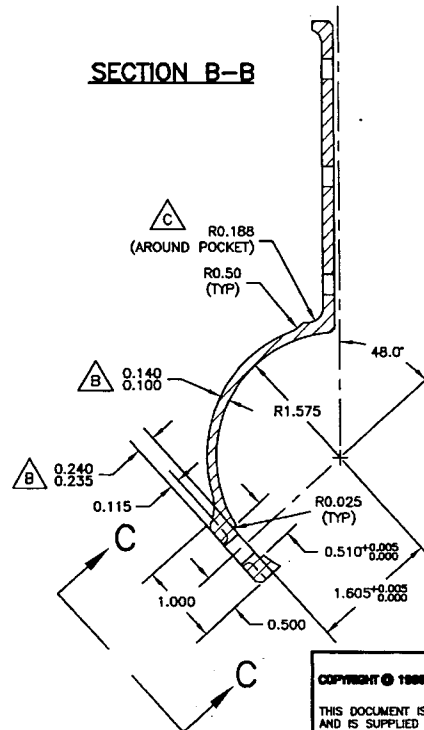
D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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BELLINGHAM, WA

DRAWING NO. D2932
REV. C
SHEET 1 OF 1

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